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D3027-7

Job Sheet 181212



Part No: D3027-7

Job Qty: 12 ea

Part Name: Clip



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 05.10.07 Added forming step and Issue P/O KJ/JLM IPP Rev:B Now on WaterJet 08-12-08
JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		8/31/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	12 pcs		8/31/18	0.00	0.32	Waterjet1		
120	QC	12 pcs		8/31/18	0.00	0.00	QC8		
130	Brake NC	12 pcs		8/31/18	0.01	0.28	Brake NC 1		
140	QC	12 pcs		8/31/18	0.00	0.00	QC5		
150	HandFinish	12 pcs		8/31/18	0.00	0.28	HandFinish1		
160	QC	12 pcs		8/31/18	0.00	0.00	QC7-1		
170	Packaging	12 pcs		8/31/18	0.00	0.00	Packaging3-1		
180	QC21-SA	12 Ea		8/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3027 ***NOTE GRAIN DIRECTION*****
Descriptions: 130 - Deburr if necessary Form as per Dwg D3027

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.2880 sf (.024 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	0	69	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clip	1.850inches ± 0.010	1.860 1.840	1.852	
2	Clip	1.870inches ± 0.010	1.880 1.860	1.871	
3	Clip	0.130inches ± 0.030	0.160 0.100	0.130	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspect ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Finishing ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____					
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressu ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____							